

5/25

SPLIT

C

DART AEROSPACE LTD	Part Number	23284
Description: Fuel Purge Canister	Part Number	D3262-041
Dwg: D3262 Rev. B	Qty	20
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) D3262-041 consists of (1) D3262-1; (1) D3262-3	JL	05.05.20	20
2	MV	Cut (2) blanks per (1) D3262-041 Cut blanks: 6.000" x 0.500" x 5.400" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 5.000" thick (M6061T6B0.500x06.000) Identify for D3262-3 Batch: 117002	J.L	05/07/07	20
3	MV	Machine as per Folio FA457 and Dwg D3262 Identify as D3262-3	J.L	05/07/10	20
4	QC2	Inspect parts as they come off the CNC machine	J.L	05/07/10	20
5	QC8	Second check	J.L	05/07/10	20
6	MV	Deburr	J.L	05/07/10	20
7	MV	Cut D3262-1 to length as per Dwg D3262 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: 1517002	J.L	05/07/24	20
8	WA	Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Pick: Qty Part Number Description Batch A/R Aluminum Rod m17552 m17192	BE	05/07/28	20
9	QC5	Inspect weld and work to Step 8	J.L	05/08/01	20
10	QC5	Pressurize canister to 10 psi and submerge under water and check for leaks as per Dwg D3262.	J.L	05/08/11	17
11	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05/08/12	4
12	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads	FC	05/08/11	4
13	QC3	Inspect Powder Coat	ML	05/08/15	4
14	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	CL	05/08/15	4
15	AC	Cost / part: 97.02	SAC	05/08/15	4
16	DC	Close W/O 97.02 Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	
C	05.03.10	Removed P/O for liquid penetrant inspection	KJ/JLM	

RELEASED